

# Work Order ID 71003

Tuesday, June 21, 2011 8:59:47 AM



Page 1

Item ID: D2153

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 6/20/2011 Start Qty: 20.00

36



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 6/20/21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2153

Rev A1

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14331 ☐ Gas Spring P/N: SL13-10 (10lb) ☐ Possible supplier: Spring Lift Corporation ☐ \*\*Note: Do not ship by air\*\*\*\* ☐ Allow an extra 7 to 10 business days for shipping\*\* ☐ Material release note is required

CA 11/06/21 (36)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

Pu/S/27 (34)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Inspect Test Spring is 10lb

5/10/21/04

Contes

(+36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71003

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Setup Start



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Start Date: 6/20/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2153 2- Remove Spring Lift name and address with Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"

*EP 11/07/05* **(36)**

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*8 11/07/06*

*counter*  
**(36)**

150

0.00



Packaging

Identify as per dwg & Stock Location: **272**

Memo

0.00

Packaging

*11/7/7* **(36)** *SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 71003**

Tuesday, June 21, 2011 8:59:47 AM



Page 3

Item ID: D2153

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Prop

Start Date: 6/20/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/07/08

MF  
11-00-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 8:59:54 AM

Page 1

Work Order ID: 71003

Parent Item: D2153

Parent Item Name: Door Prop





Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SL69-BS  Ball Stud		Purchased	No			100	Each	26.0000	2	40			
<div> <div>Location</div> <div>ST397</div> <div>116475</div> </div> <div> <div>Loc Qty</div> <div>26</div> <div>26</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN960JD516  Washer	NAS1149D0563J	Purchased	No			130	Each	0.0000	2	40			
<div> <div>Location</div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2153P  Door Prop		Purchased	No			130	Each	0.0000	1	20			
<div> <div>Location</div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3015-3  Locknut		Manufactured	No			130	Each	700.0000	2	40			
<div> <div>Location</div> <div>ST030</div> <div></div> </div> <div> <div>Loc Qty</div> <div>700</div> <div>200</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

6/21/07/05  
 M118145 (46)  
 26  
 6/21/07/05  
 6/21/07/05  
 6/21/07/05  
 72

4 M118206  
 (72x)

71003  
 (36x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

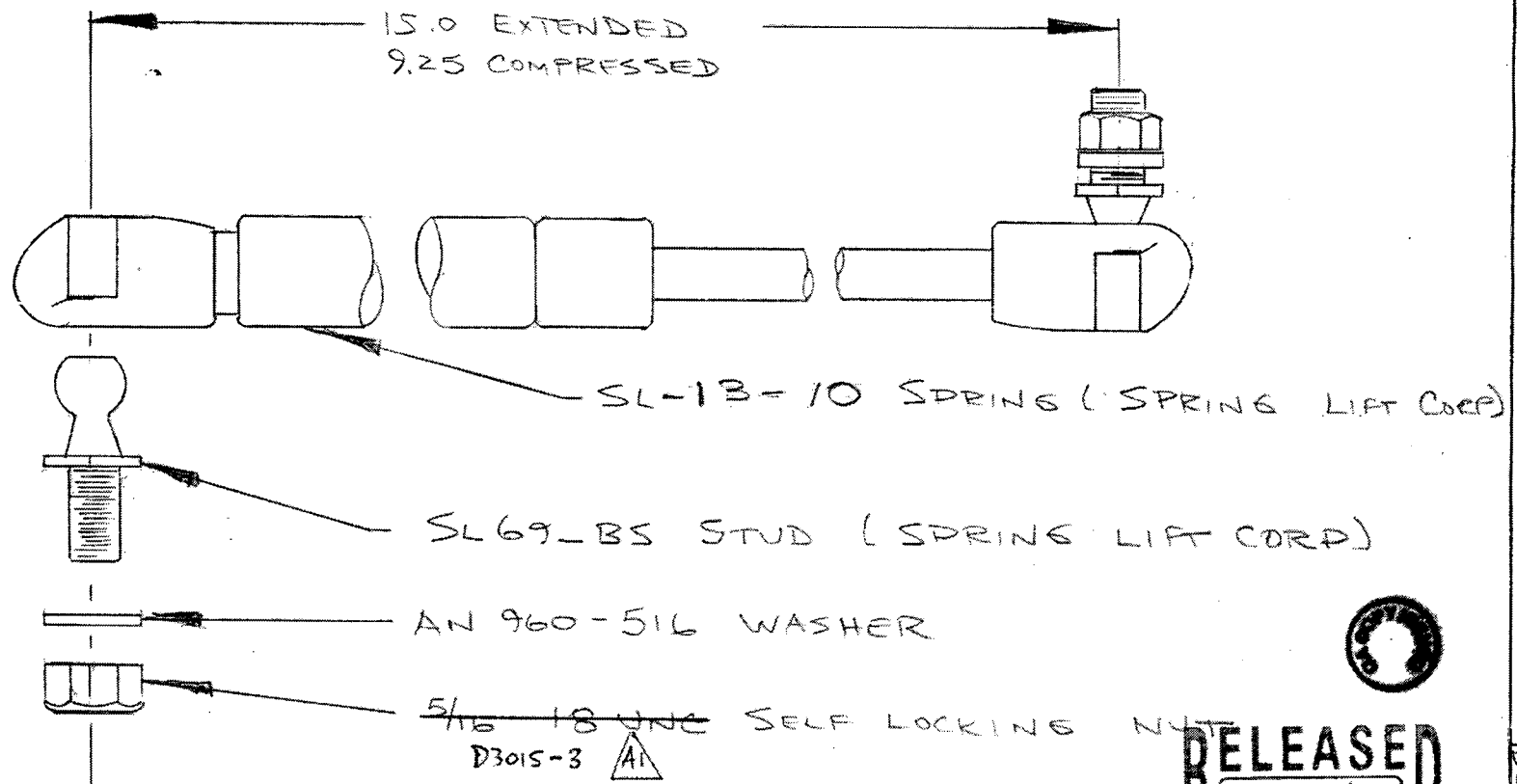
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71063

*110627*



**RELEASED**  
96/07/16

<b>AI</b> CHANGE TO D3015-3 SL 13-10 WAS SL 32-15		REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE D-DIMPLE C-COUNTERSINK LENGTH DASH NO W-SPOTWELD BASIC CODES 82-MS20470AD 88-MS20476AD	PART NO. CONTRACT NO. DRAWN HATTON DATE 27.2.92 DESIGN HATTON STRESS CHECKED HATTON 27/2/92 CLIENT	DESCRIPTION <b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA TITLE GAS SPRING ASSEMBLY CODE DZ153 SCALE 1:1 SHT 1 OF 1	MATERIAL SPEC./VENDOR
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7142 5. HOLES PER AND 10087		LIMITS 1. TOLERANCES — JOE 2 .030 KEN 2 .010 2. ANGLES 1° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	REPORT ALL DISCREPANCIES — DO NOT SCALE				

DZ153

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO14331

Purchase Order Date 6/21/2011

PO Print Date 6/21/2011

Page Number 1 of 1

Order From : VU-ATT001  
ATTWOOD  
25349 NETWORK PLACE  
CHICAGO, IL 60673-1253  
US

Contact Name  
Vendor Phone 616-897-2285  
Vendor Fax 616-897-2337  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency USD  
FOB Destination-Collect

*revised \$*

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
6/21/2011

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2153P	Door Prop	6/28/2011 Yes	36.00 Each	FedEx PI collect	\$4.1900	\$150.84
Special Inst:			AS PER DWG D2153 REV.A B71003 ATTWOOD P/N: GAS SPRING SL13- 10 (10LBS)				
2	SL69-BS	Ball Stud	6/28/2011 Yes	100.00 Each	FedEx PI collect	\$0.8500	\$85.00
PO Total:							\$235.84

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 6/21/2011

*ez*  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

**attwood**  
genuine ingenuity  
TELEPHONE: 615-897-2290

**MotorGuide**  
NEVER STOP.

CUST: 68580 MST: 35515-CO

COLLECT

PRO NO: 442 79313  
SHIP VIA: UPS GROUND  
BOL: 00226970002548601

FREIGHT: \_\_\_\_\_

A ATTWOOD / MOTORGUIDE  
B  
C  
D 101A NORTH MONROE  
E LOWELL MI 49331-0260

F DART AERO LTD.  
G 1970 ABERDEEN STREET  
H

HAWKESBURY ON K6A 1K7

CRTS: 2 PD#: PD14331

NET: 15 DATE: 06/21/11

SPUR: 8

LABEL NO:  
5579160001

--ROUTING GUIDE INFO --

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART#	UPC	DESCRIPTION / SKU	LN	QTY	WGT
	36	Z09211	EA	SL13-10-1		GS SPRNG 15" EXTC 10# BL	1	36	12
	100	Z10321	EA	SL69-B5-1		10MM BALL STUD W/THRD	2	100	3

*Sulo Hloy*